

Date: Friday, 7/21/2006 1:55:02 PM  
User: Kim Johnston

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 205 SKIDTUBE "I" BEAM						
<b>Job Number</b>	: 28025								
<b>Estimate Number</b>	: 10346								
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D2596						
<b>This Issue</b>	: 7/21/2006	<b>S.O. No.</b>	: N/A						
<b>Prsht Rev.</b>	: NC		<b>Drawing Number</b>	: D2596 REV C					
<b>First Issue</b>	: N/A	<b>Type</b>	: LANDING GEAR	<b>Project Number</b>	: N/A				
<b>Previous Run</b>	: 27655		<b>Drawing Revision</b>	: C					
<b>Material</b>			<b>Material</b>	: N/A					
<b>Written By</b>	Step 6 COMMENT Below			<b>Due Date</b>	: 7/31/2006	<b>Qty:</b>	12	<b>Um:</b>	Each
<b>Checked &amp; Approved By</b>	06.07.21								
<b>Comment</b>	Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D								

#### **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D25003100	Ext'n -'I' Beam Web 4"
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Extrusion "I" Beam Web 4"	
	Pick;	
	Qty Part Number Description Batch	
	1 D2500-3-100 Extrusion B25751 IT 06-08-11 (1)	
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" IT 06-08-11 (1) 2- Use Jig DT8093 to drill pilot holes #30 IT 06-08-14 (1) 3- Open to 0.625" diameter using a uni-bit IT 06-08-14 (1) 4- Deburr IT 06-08-14 (1)	
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005.4.1 IT 06-08-14 (1)	
4.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
5.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LG Pmc 06-08-14 (1)	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 NoDQA: Date: 06/08/15

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 28025

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 DC

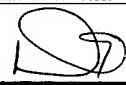
DOCUMENT CONTROL



(12)

Comment: DOCUMENT CONTROL

Inspection Level 21



06/08/15

Job Completion



U 06/08/15

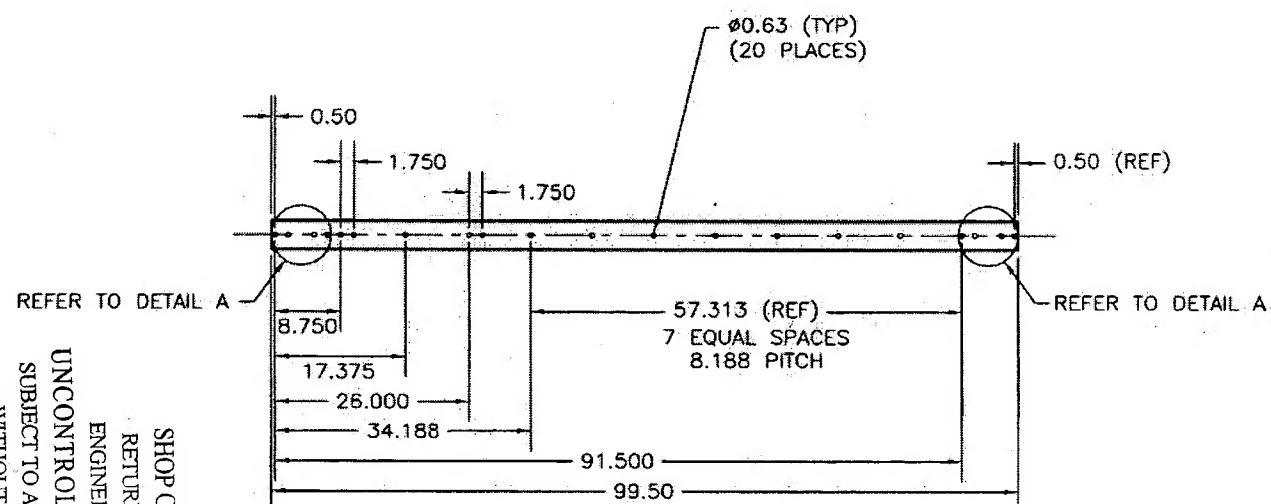
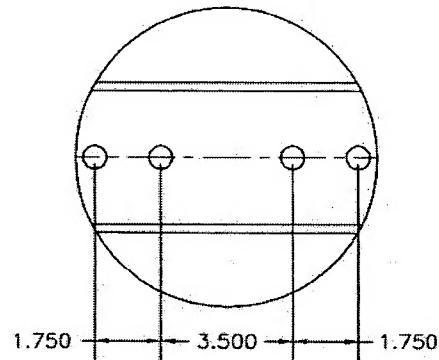
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DETAIL A  
SCALE 5:24



MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED CCP  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28025

RELEASED  
1980917 BS

OACG/CY  
1980917

DESIGN		DRAWN BY	DART AEROSPACE LTD		
CHECKED	APPROVED	DATE	DRAWING NO.	TITLE	REV. C
		98.09.14	D2596	205 WEB	
A		96.09.16		NEW ISSUE	
B		97.07.23		Ø0.63 HOLE WAS Ø0.56	
C		98.09.14		INCORPORATED DEO 9097	
					SCALE 1:24